

Date: Monday, 1/16/2006 4:11:20 PM  
 User: Kim Johnston

## Process Sheet

|                                    |   |                           |                                      |
|------------------------------------|---|---------------------------|--------------------------------------|
| <b>Customer</b> :                  | CU-DAR001 Dart Helicopters Services         | <b>Drawing Name</b> :     | COLLECTIVE LOCK                      |
| <b>Job Number</b> :                | 25501                                       |                           |                                      |
| <b>Estimate Number</b> :           | 11948                                       |                           |                                      |
| <b>P.O. Number</b> :               | N/A   | <b>Part Number</b> :      | D3372041                             |
| <b>This Issue</b> :                | 1/16/2006                                   | <b>S.O. No.</b> :         | N/A                                  |
| <b>Prsht Rev.</b> :                | NC  | <b>Drawing Number</b> :   | D3372 REV B                          |
| <b>First Issue</b> :               | N/A   | <b>Project Number</b> :   | N/A                                  |
| <b>Previous Run</b> :              | N/A   | <b>Drawing Revision</b> : | B                                    |
|                                    | <b>Type</b> :                               | <b>Material</b> :         | N/A                                  |
|                                    | SMALL / MED FAB                             | <b>Due Date</b> :         | 1/20/2006                            |
| <b>Written By</b> :                | <u>SEE COMMENT BELOW</u>                    |                           | <b>Qty:</b> <u>4</u> <b>Um:</b> Each |
| <b>Checked &amp; Approved By</b> : | <u>SEE COMMENT BELOW</u>                    |                           |                                      |
| <b>Comment</b> :                   | Est Rev:A Removed from 9 Digit 06-01-13 JLM |                           |                                      |

## Additional Product

Job Number:



|                |                              |                      |
|----------------|------------------------------|----------------------|
| <b>Seq. #:</b> | <b>Machine Or Operation:</b> | <b>Description :</b> |
|----------------|------------------------------|----------------------|

|     |        |       |
|-----|--------|-------|
| 1.0 | D27287 | Decal |
|-----|--------|-------|



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2728-7 Decal B 22554

|     |        |           |
|-----|--------|-----------|
| 2.0 | D33721 | Main Body |
|-----|--------|-----------|



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3372-1 Main Body B 22228

|     |        |                |
|-----|--------|----------------|
| 3.0 | D33725 | Cam Lock Shaft |
|-----|--------|----------------|



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3372-5 Cam Lock Shaft B 22290

|     |        |             |
|-----|--------|-------------|
| 4.0 | D33727 | Slider Body |
|-----|--------|-------------|



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3372-7 Slider Body B 22291

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: D3372-041 PAR #: N/A Fault Category: Prod / FMS ASS LAGE NCR: Yes No DQA: Yes Date: 06/02/02  
 QA: N/C Closed: Yes Date: 06/02/02

| NCR: <u>25501</u> |      | WORK ORDER NON-CONFORMANCE (NCR)   |                             |   |                |                                |                       |                                |
|-------------------|------|--|-----------------------------|---|----------------|--------------------------------|-----------------------|--------------------------------|
| DATE              | STEP | Description of NC<br>Section A   | Corrective Action Section B |   |                | Verification<br>Section C      | Approval<br>Chief Eng | Approval<br>QC Inspector       |
|                   |      |  | Initial<br>Chief Eng        | Action Description<br>Chief Eng               | Sign &<br>Date |                                |                       |                                |
| 06/02/01          | 16   | 2 Lock were<br>perap after<br>welding  | <i>[Signature]</i>          | Scrap + destroy<br><del>replace</del> replace | SB<br>06/02/01 | <i>[Signature]</i><br>06-02-01 | <i>[Signature]</i>    | <i>[Signature]</i><br>06-02-01 |
| 06/02/01          | 16   | D3372-041<br>1 part had the<br>wrong keys. Keys<br>were identify wrong<br>+ 2 D3372-041 was burned<br>by the welding / | <i>[Signature]</i>          | Scrap + destroy<br>replace                    | SB<br>06/02/02 | <i>[Signature]</i><br>06-02-02 | <i>[Signature]</i>    | <i>[Signature]</i><br>06-02-02 |
|                   |      |  |                             |   |                |                                |                       |                                |

NOTE: Date & initial all entries

Date: Monday, 1/16/2006 4:11:20 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COLLECTIVE LOCK

Job Number: 25501

Part Number: D3372041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D33731KA

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3373-1 Cam Lock ~~B22157~~ B23643

6.0

AN542A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN5-42A Bolt M16762

7.0

516WC

SS Flat Washer 5/16



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 5/16WC SS Flat Washer M19611

A/RN/ALocktite 262 M16507

8.0

D33841

Cyclic Sock



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3384-1 Cyclic Sock B22346

9.0

CBL460

Loop Sleeve



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CBL-460 Loop Sleeve B19474

10.0

CBL1240

Cable



Comment: Qty.: 0.6999 f(s)/Unit Total : 3.4997 f(s)

Pick:

Qty Part Number Description Batch

8" CBL-1240 Cable M16713

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Monday, 1/16/2006 4:11:21 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COLLECTIVE LOCK

Job Number: 25501

Part Number: D3372041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

AN960416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN960-416 Washer M5519

12.0

HX81

1/4"-20 SHCS 3/8" long



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 HX-81 1/4"-20 SHCS 3/8" long M16971

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Fabricate D3372-3 using AN5-42A bolt as per Dwg D3372

Identify as D3372-3

FF 06-02-01

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/02/01

15.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Open Cam Lock package. Keep keys, lock body, lock body nut, flat cam and lock barrel. Discard the rest.

2-Fabricate D3369-5 spacer using the flat cam as per Dwg D3369 Identify as D3369-5

SB 06/02/01

16.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Tack weld lock shaft as per Dwg D3372

Qty Part Number Description Batch

A/R/N/A

SS Rod

M19555

PD 06-02-01

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Monday, 1/16/2006 4:11:21 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COLLECTIVE LOCK

Job Number: 25501

Part Number: D3372041

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble D3372-053 as per Dwg D3372. Apply a drop of permanent locktite 262 to the threads

Qty Part Number Description Batch

A/R N/A Locktite 262 ML6507

Identify as D3372-053

2-Assemble D3372-051 as per Dwg D3372. Identify as D3372-051 and attach keys Ensure that assembly locks and unlocks smoothly.

3-Assemble lanyard to cyclic sock as per Dwg D3384

4-Assemble D3384-043 to D3372-051 using 1/4"-20 socket head cap screw and washers as per Dwg D3371.

SB 06/02/01

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06.02.01

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:                     

Record Key #

~~C413A~~ C420A  
~~C413A~~ C420A  
~~C413A~~ C420A  
~~C413A~~ C420A

C 206/02/01 4

20.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

545 06/02/02

(4)

SP 06/02/02 (4)

Job Completion



| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

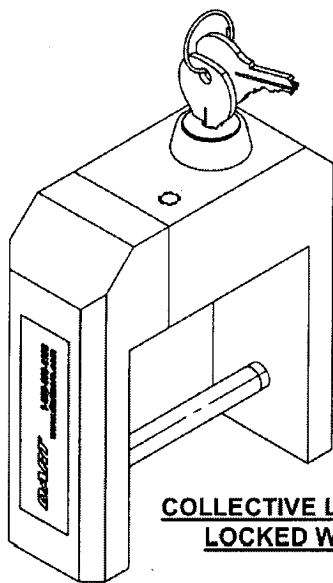
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

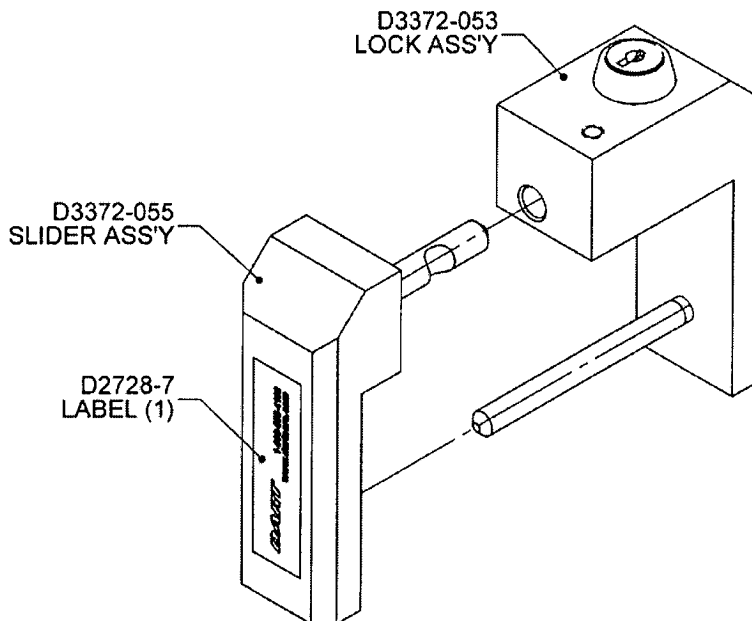
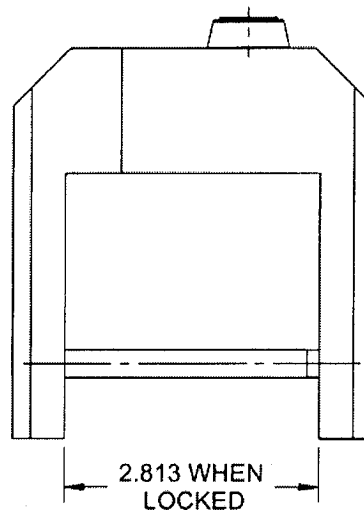




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| DATE<br><b>05.02.23</b>       |                                | TITLE<br><b>COLLECTIVE LOCK</b>  | SCALE<br>1:2           |
| A                             | 05.01.10                       | NEW ISSUE  |                        |
| B                             | 05.02.23                       | REDESIGN FOR STANDARD 1/4 TURN LOCK,<br>D3369-5 SUPERCEDES D3372-11 (OBSOLETE) |                        |



**COLLECTIVE LOCK SHOWN  
LOCKED WITH KEYS**



**D3372-051 AS350 COLLECTIVE LOCK ASS'Y**

**NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

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*[Signature]*  
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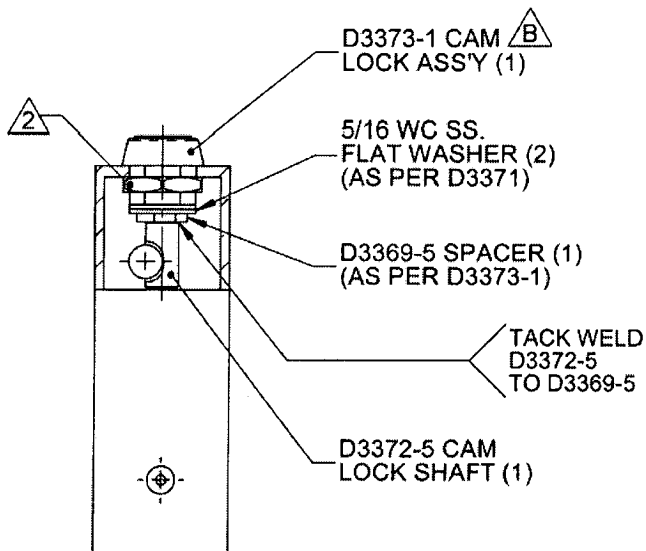
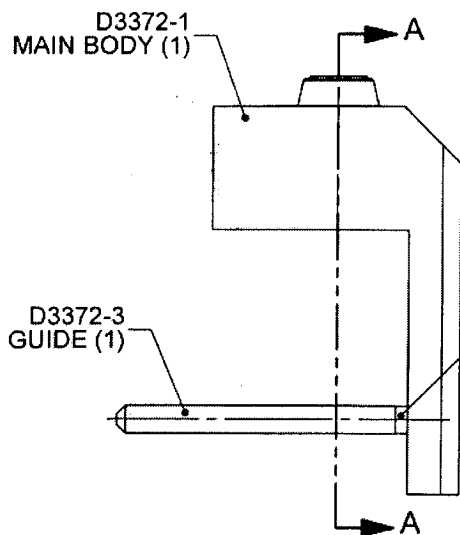
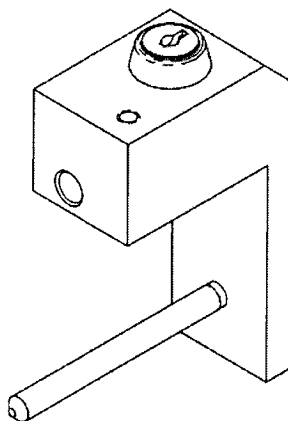
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| DATE<br><b>05.02.23</b>       |                                | TITLE<br><b>COLLECTIVE LOCK</b>                          | SCALE<br>1:2           |

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**SECTION A-A**

**D3372-053 LOCK ASS'Y**

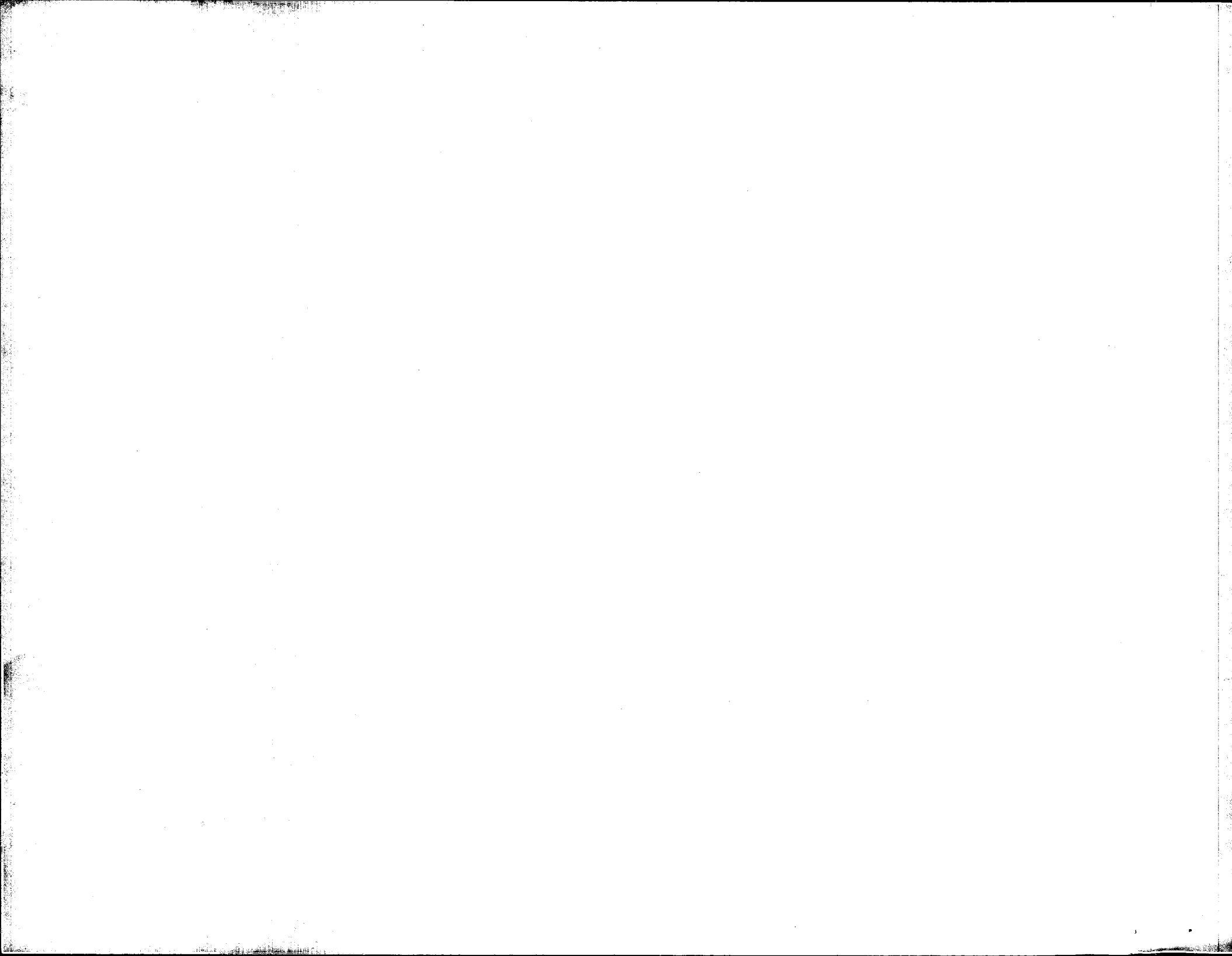
**NOTES:**

- 1) WELD PER DART QSI 004
- 2) APPLY THREADLOCKER LOCTITE 262 ON THREADS

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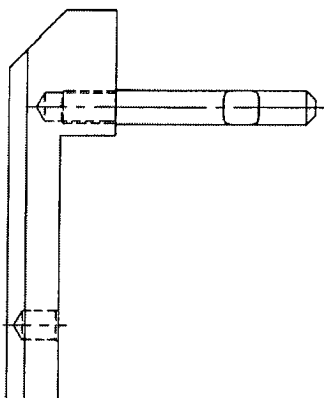
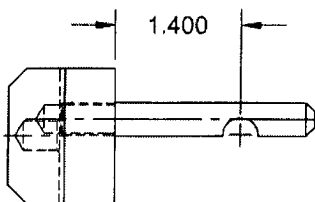
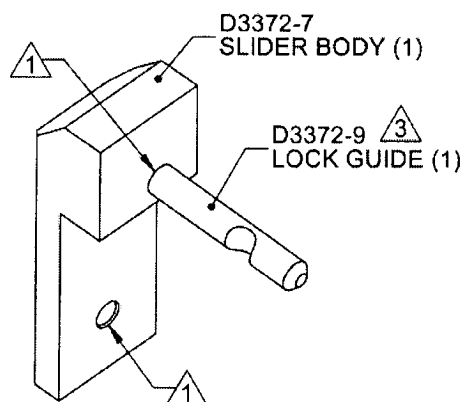
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| DATE<br><b>05.02.23</b>       |                                | TITLE<br><b>COLLECTIVE LOCK</b>                          | SCALE<br>1:2           |

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05/04/23**D3372-055 SLIDER ASS'Y****NOTES:**

- 1) COVER INSIDE HOLES AND D3372-9 PRIOR PAINTING
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) APPLY THREADLOCKER LOCTITE 262 ON D3372-9 THREADS PRIOR ASSEMBLY
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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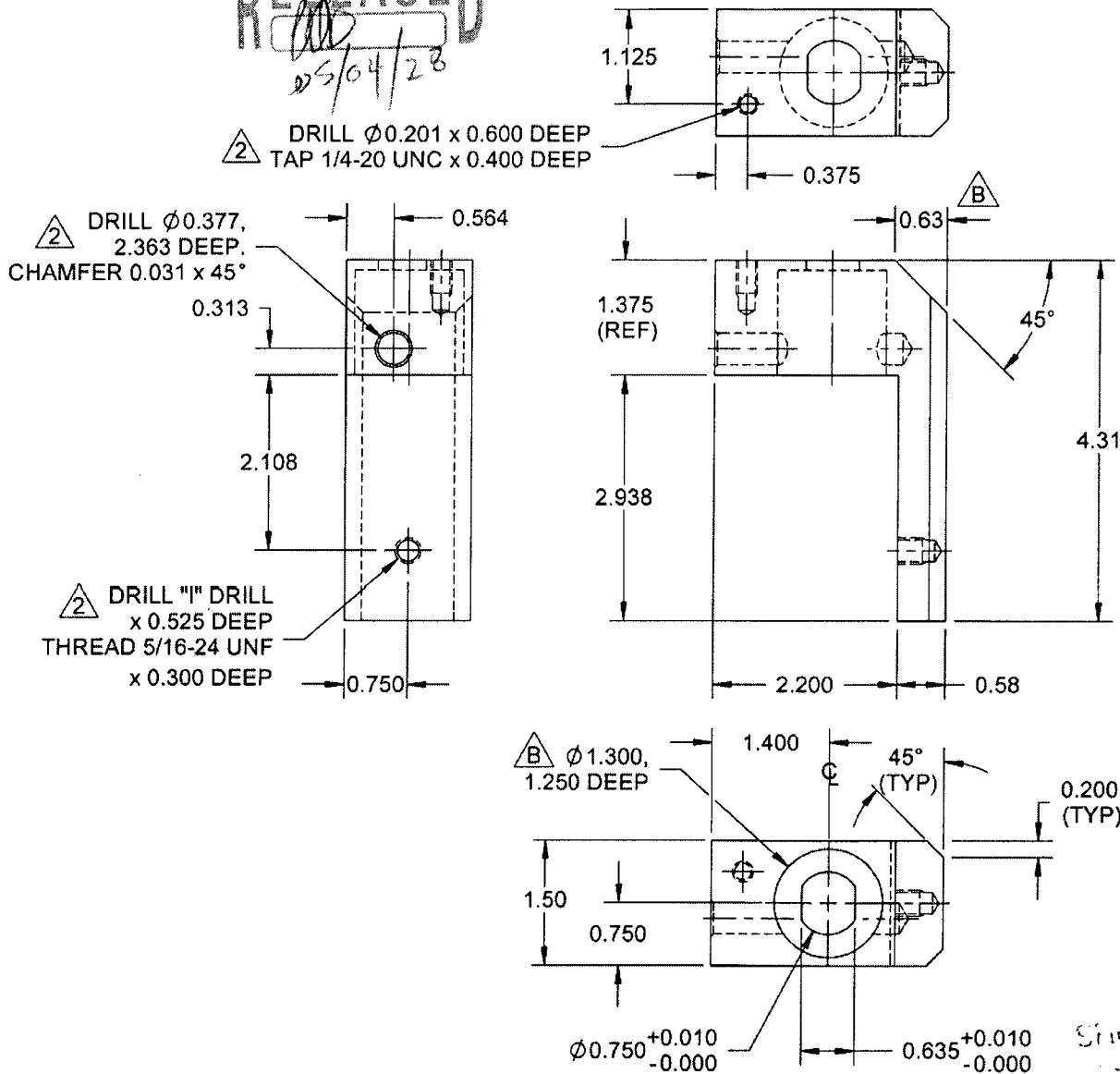
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|                         |                         |  |                        |
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| DATE<br><b>05.02.23</b> |                         | TITLE<br><b>COLLECTIVE LOCK</b>                          | SCALE<br>1:2           |

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05/04/23**D3372-1 MAIN BODY****NOTES:**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)  
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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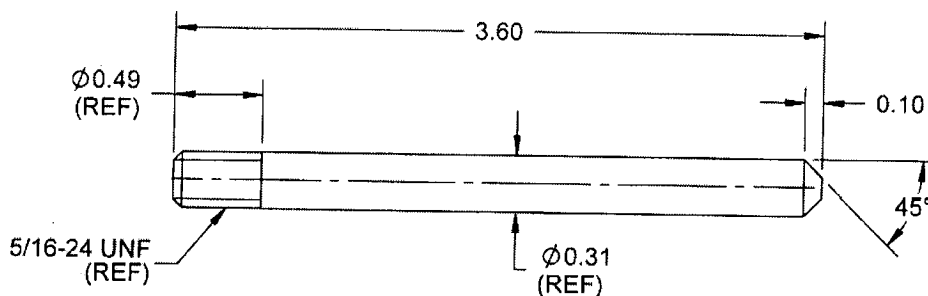
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| DATE<br>05.02.23              |                                | TITLE<br>COLLECTIVE LOCK                          | SCALE<br>1:1           |

## SPECIFICATION CONTROL DRAWING

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### D3372-3 GUIDE

#### NOTES:

- 1) MATERIAL: AN5-42A BOLT MODIFIED AS SHOWN.
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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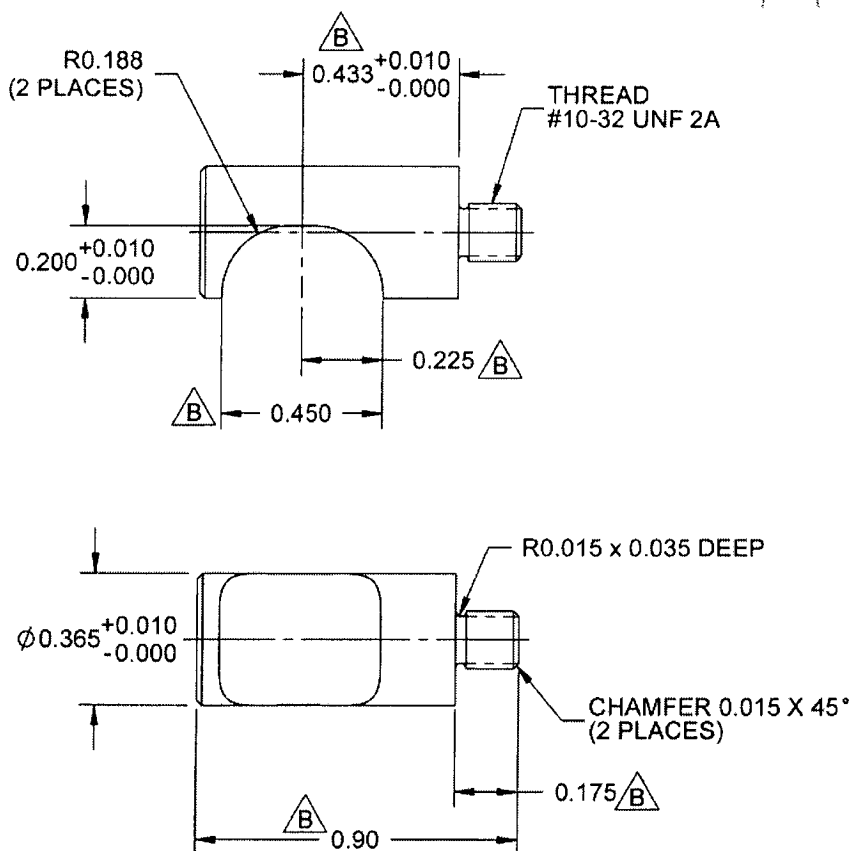
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| DATE<br><b>05.02.23</b> |                         | TITLE<br><b>COLLECTIVE LOCK</b>                          | SCALE<br>2:1           |

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### D3372-5 CAM LOCK SHAFT

#### NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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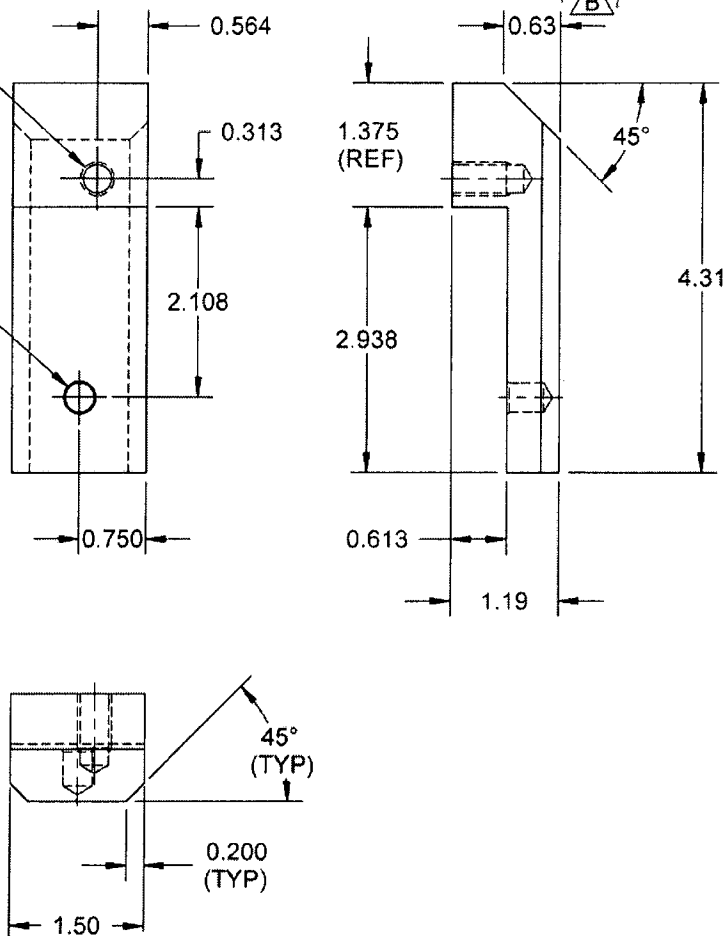
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| DATE<br><b>05.02.23</b>       |                                | TITLE<br><b>COLLECTIVE LOCK</b>                          | SCALE<br>1:2           |

DRILL  $\phi 0.332$   
("Q" DRILL) x 0.881 DEEP,  
THREAD 3/8-24 UNF x 0.600 DEEP

DRILL  $\phi 0.323$   
("P" DRILL) x 0.500 DEEP  
CHAMFER 0.030 x 30°



### D3372-7 SLIDER BODY

#### NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)  
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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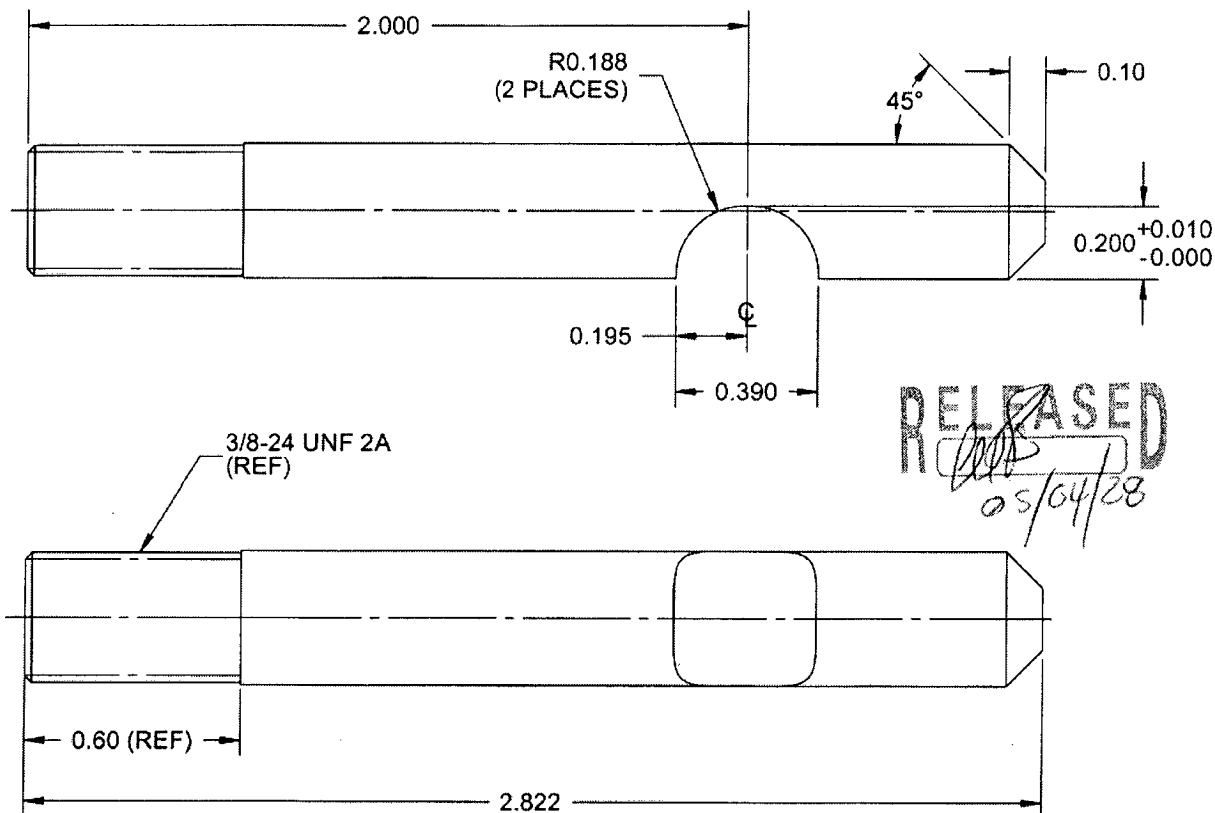
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| DATE<br>05.02.23              |                                | TITLE<br>COLLECTIVE LOCK                          | SCALE<br>2:1           |

## SPECIFICATION CONTROL DRAWING



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### D3372-9 LOCK GUIDE

#### NOTES:

- 1) MATERIAL: AN6-36A BOLT, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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